

Work Order ID 66011

Tuesday, February 01, 2011 1:22:05 PM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Item Name: Aft Tube Assembly

Stop



Start Date: 2/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-02-01 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	Rev H/ DEO

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo

0.00

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: H

scribe batch # on fwd end at 90 degree

SL 11/02/08

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



SL 11/02/08

QC

Quality Control

Memo

0.00

111

QC8- Inspect parts - second check

0.00



ark 11/02/08

QC

Quality Control

Memo

0.00

1 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: U

SL 11/02/14

130



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

SL 11/02/14

140



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

RL 11.2.15

O

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Skidtubes

0.00

11-2-23

Skidtubes

Memo

0.00

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160



BENDING MACHINE - SKIDTUBES

0.00

11-2-23

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

Form as per Dwg D3391 Using Bend Prog 3391025

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

1 Ø 3E 110223

4.3.95"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

11-2-23

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

0.00

Sma/73

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

1 0 2014/01/23

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

DP

11-2-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

220

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Skidtubes

Skidtubes

Memo

0.00

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: m110227
exp. date: 08/2011
cure time 12hrs as per QSI0015

BE 11/02/23

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

M 11 02 24 0

235



HandFinish

Pressure Wash per QSI005 4.3

0.00

L 11 02 25

Hand Finishing

Memo

0.00

AND REALODINE AS PER PAR09-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

240



Powdercoat

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M 115951

Memo

8:05 320°
START TIME:
OVEN TEMPERATURE:
FINISH TIME: 8:35

0.00

1

BL 11-2-25

250



QC

Quality Control

QC3- Inspect Part Finish

0.00

1

BL 11/03/02

260



HandFinish

Hand Finishing

HandFinishing

0.00

1

BL 11/03/02

Memo
 1-Install inserts as per Dwg D3391
 2-Install Aft Cap as per Dwg D3391
 A/R Sikaflex-241/-291 A115114
 Sikaflex expiry date: 11/01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

270



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S ulogloz

280



Packaging

Packaging

Identify as per dwg & Stock Location: w10

0.00

D412-7412-043/1563178

1

9

H ulogloz

290



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/03/02 JJ

11.03.02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, February 01, 2011 1:21:58 PM

Page 1

Work Order ID: 66011



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090 		Manufactured	No			100	Each	26.0000	1	1		21 11/02/08	

ALUMINUM EXTRUSION

Location	Loc Qty	Loc Code
LG	26	1
56572	26	

D3670-4-200



SPACER

Manufactured No

230 Each 56.0000



8 66041 8402

Location	Loc Qty	Loc Code
LG	56	
57349	34	
63317	22	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66011



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

D2646



Manufactured No

270

Each

83.0000

1

1

Aft Cap

M 1103102

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-4	13	
57332	13	X1
FP6	16	
52663	3	
62678	12	
63633	1	
Return 2010	54	
62678	54	

D3537-1



Manufactured No

270

Each

54.0000

1

1

Wearpad

M 1103102

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	54	B65057
64424	54	X1

D3537-7



Manufactured No

270

Each

17.0000

1

1

Wearpad

M 1103102

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP16	17	
56831	9	
65146	8	X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 66011



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3553-1



Manufactured No

270

Each

29.0000

1

1



M u103102

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	29	
33868	1	
<u>56568</u>	28	

D3553-3



Manufactured No

270

Each

33.0000

1



X1
M u103102

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	33	
<u>53480</u>	33	

D3672-1



Manufactured No

270

Each

1,307.000

2



X1
M u103102

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST077	1307	
42329	10	
<u>52505</u>	297	
64177	1000	

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Aft Tube Assembly

Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

729.0000

14

14



JUL

1103102

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
PKG11	480	A/L115581
114723	480	
ST281	114	
116049	114	
ST282	96	
110511	10	
115911	86	
ST381	39	
114654	39	

ALS4-1032-225

Purchased

No

270

Each

4,024.000

12



JUL

1103103

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
PK011	4024	
110768	4024	

AN3C4A

Purchased

No

270

Each

2,072.000

6



JUL

1103102

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	2072	
115300	25	
116075	947	
116590	100	
116704	1000	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 2/2/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A



Purchased

No

270

Each

946.0000

4

4



el u103102

Bolt

Location	Loc Qty	Loc Code
ST350	946	
114330	11	
115015	13	
115371	18	
115422	100	
115594	6	
<u>115835</u>	198	
116419	500	x4
116549	100	

AN960C10L

NAS1149C0332

Purchased

No

270

Each

25.0000

10

10



el u103102

washer

Location	Loc Qty	Loc Code
ST245	25	
107534	25	M116304

y10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD	Work Order:	66011
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	/		m-tape	
3.500	+/-0.010	3.503	/		Vern SL-3	
88.93	+/-0.030	88.937	/		m-tape	
44.995	+/-0.030	45.00	/		"	
Ø3.200	+/-0.010	3.203	/		mic/CNC-05	
88.93	+/-0.030	88.937	/		m-tape	
Ø3.750	+/-0.010	3.746	/		Vern SL-3	
30° x 160"	+/-0.010	30° x 160"	-			

Measured by: SL

Date: 11/02/08

Audited by: GRL

Date: 11/02/08

HAAS Section						
1.526	+0.000/-0.030	1.515	/		Vern SL-3	
7.500	+/-0.010	7.500	/		Vern CNC-02	
27.750	+/-0.010	27.750	/		m-tape	
31.750	+/-0.010	31.750	/		"	
35.250	+/-0.010	35.250	/		"	
3.300	+/-0.010	3.297	/		Vern CNC-02	
0.200	+/-0.010	.201	/		"	
3.520	+/-0.010	3.515	/		mic JLM4	
0.687	+0.010/-0.000	0.692	/		Vern evc-02	
R0.062	+/-0.010	.062	/		"	
Ø0.484	+0.005/-0.001	.487	/		"	

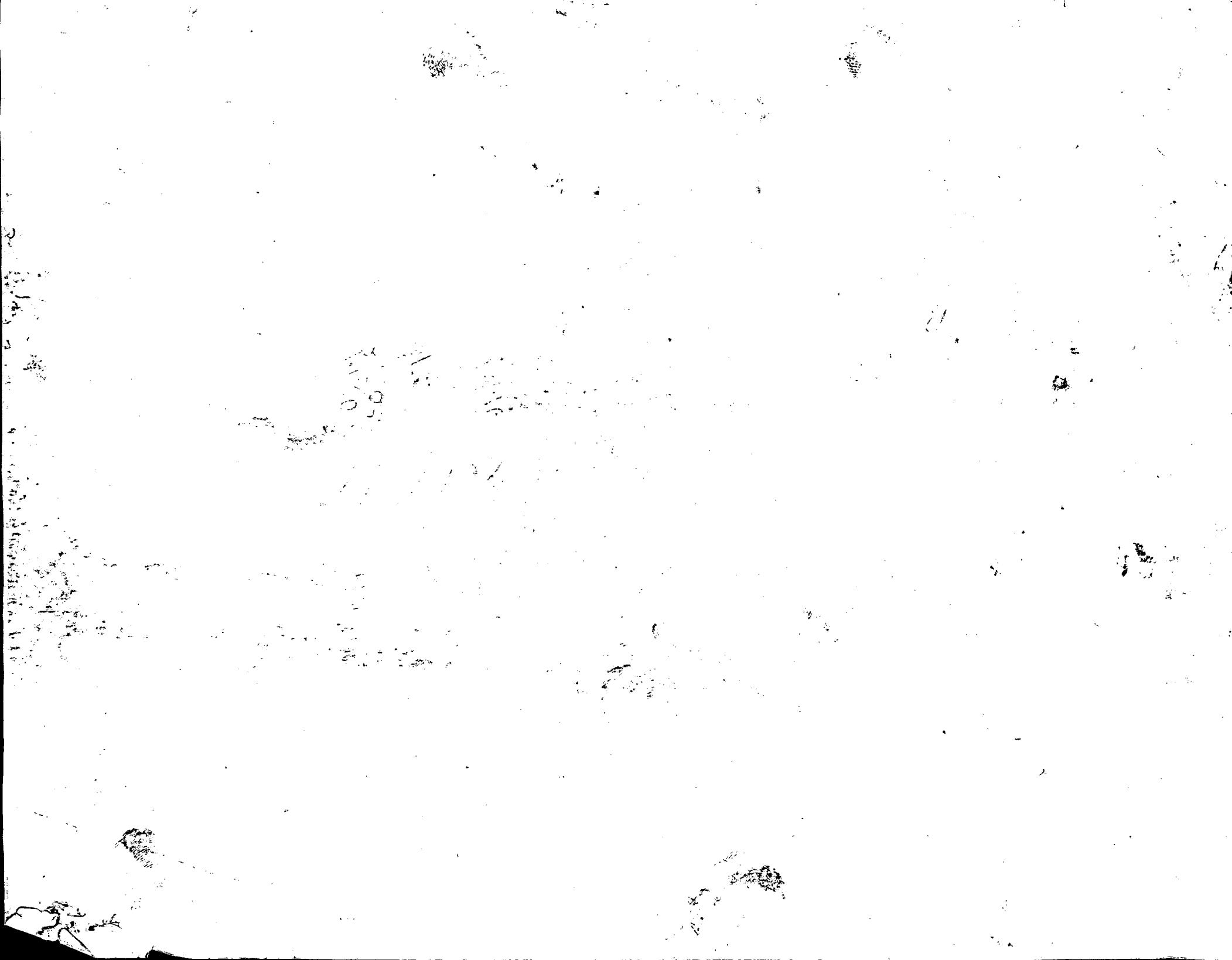
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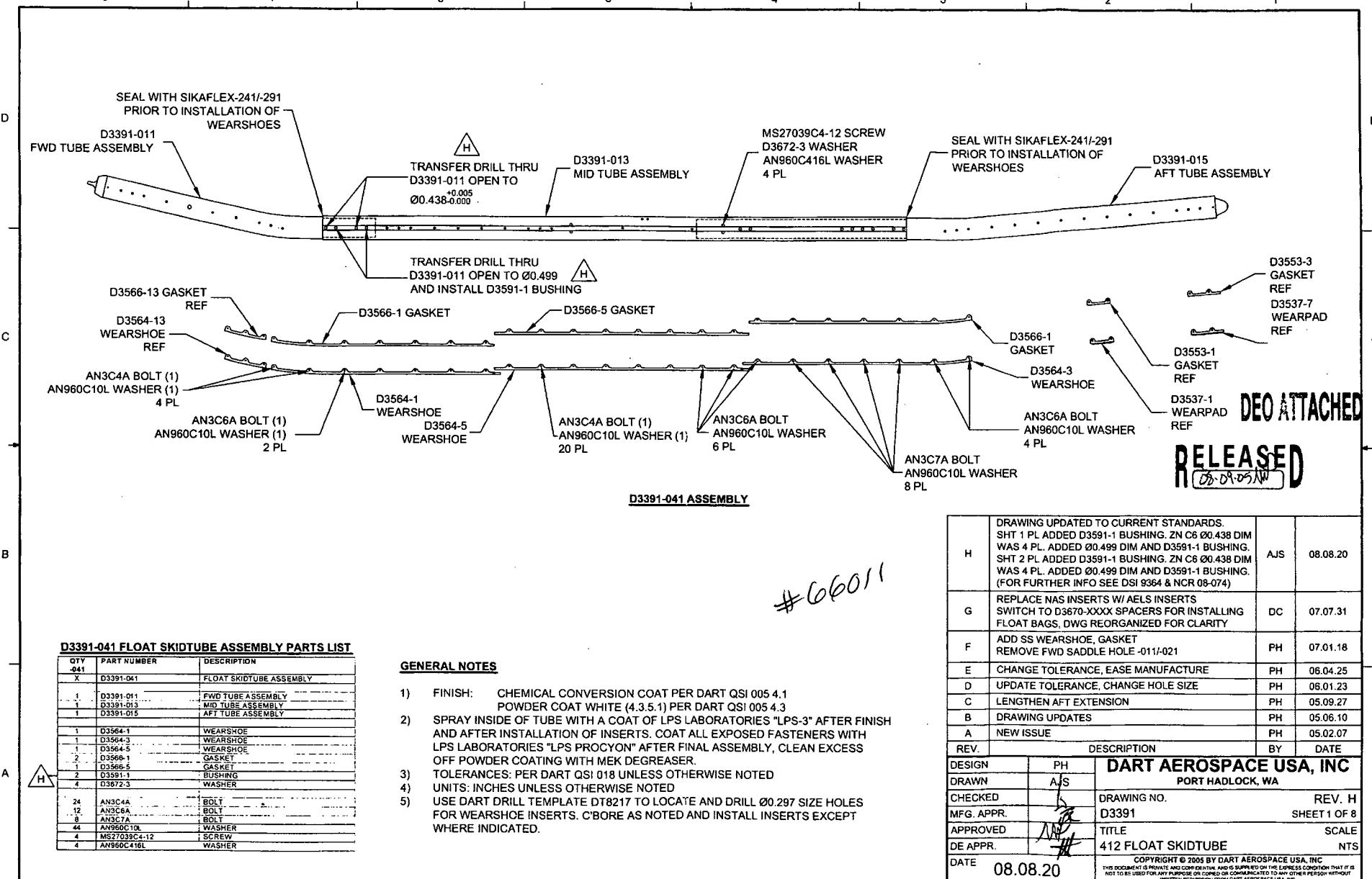
Date: 11/02/14

Audited by: SL

Date: 11/2/15

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	M





QTY	PART NUMBER	DESCRIPTION
-041		FLOAT SKIDTUBE ASSEMBLY
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3872-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS7039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DS1 9364 & NCR 08-074)			AJS	08.08.20
G	REPLACE NAS INSERTS W/AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY			DC	07.07.31
F	ADD SS WEAHROHUE, GASKET REMOVE FWD SADDLE HOLE -011-021			PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE			PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE			PH	06.01.23
C	LENGTHEN AFT EXTENSION			PH	05.09.27
B	DRAWING UPDATES			PH	05.06.10
A	NEW ISSUE			PH	05.02.07
REV.	DESCRIPTION		BY	DATE	
DESIGN	PH	DART AEROSPACE USA, INC			
DRAWN	A/S	PORT HADLOCK, WA			
CHECKED	<i>b</i>	DRAWING NO.	REV. H		
MFG. APPR.	<i>b</i>	D3391	SHEET 1 OF 8		
APPROVED	<i>AB</i>	TITLE	SCALE		
DE APPR.	<i>b</i>	412 FLOAT SKIDTUBE	NTS		
DATE	08.08.20		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE USA, INC.		

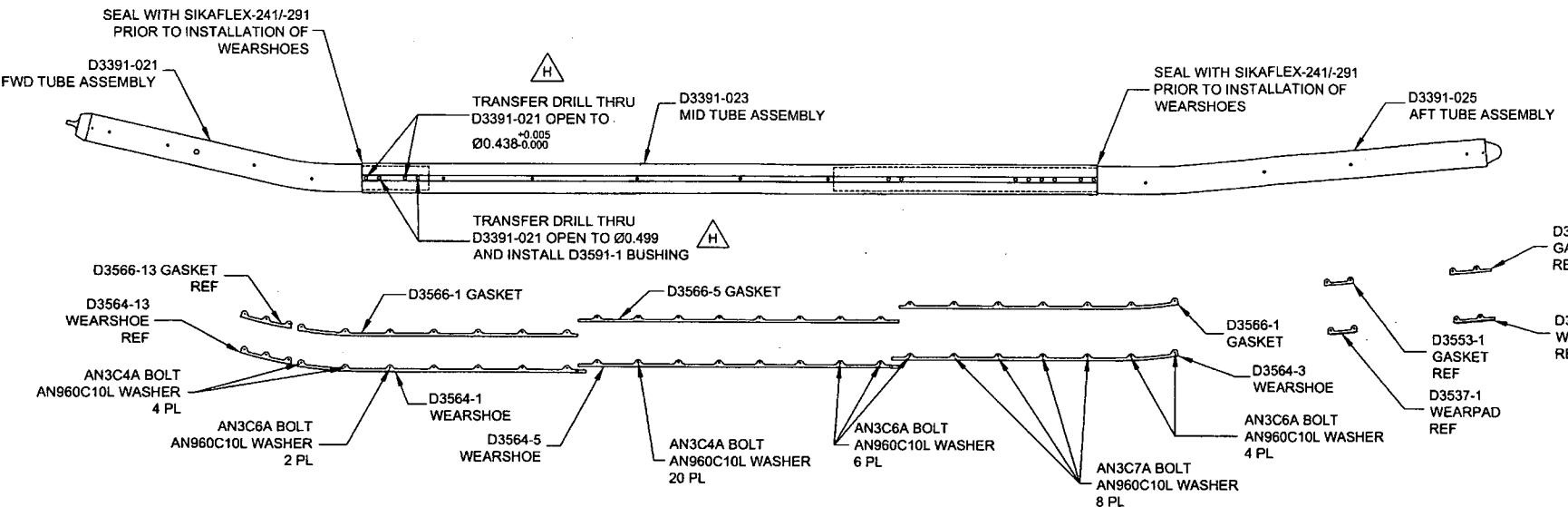
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES
FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

#66011

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AUS	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		REV. H
APPROVED		D3391
DE APPR.		SHEET 2 OF 8
DATE 08.08.20		TITLE
		SCALE
		NTS
412 FLOAT SKIDTUBE		

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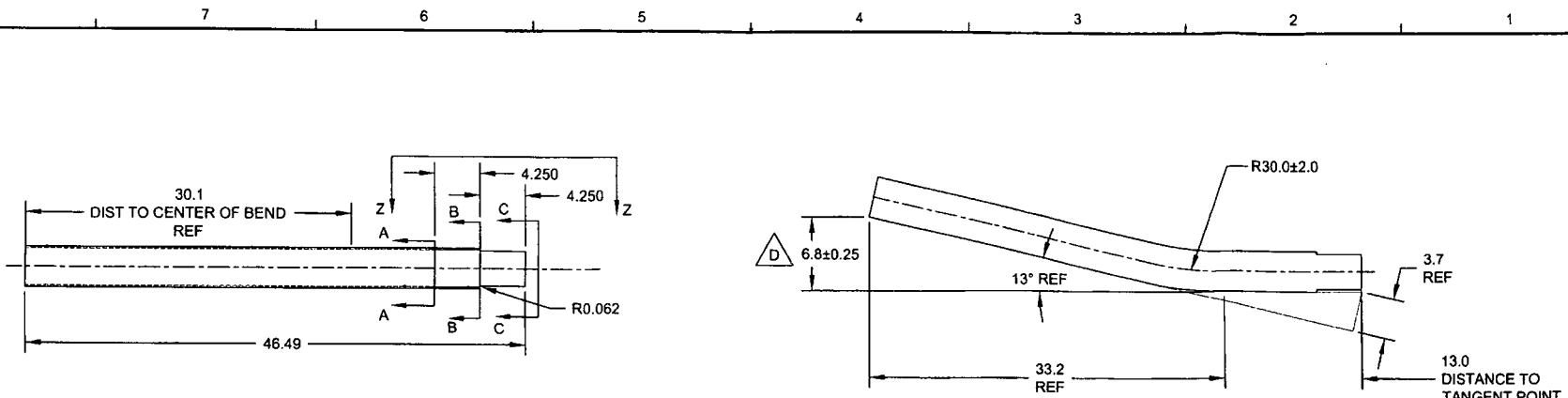
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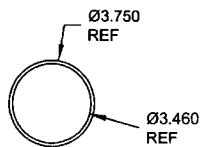
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

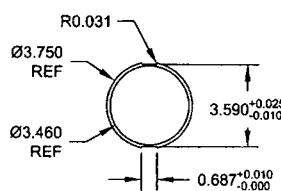
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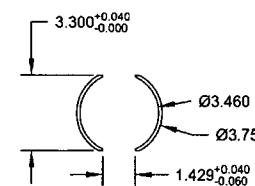
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



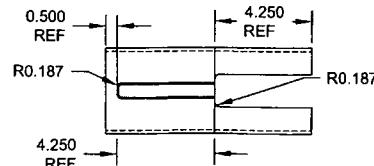
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

#66011
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RELEASED
(09-05-05)

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AUS	PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. H
APPROVED	<i>[Signature]</i>	D3391
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 8
DATE	08.08.20	TITLE
		412 FLOAT SKIDTUBE
		NTS

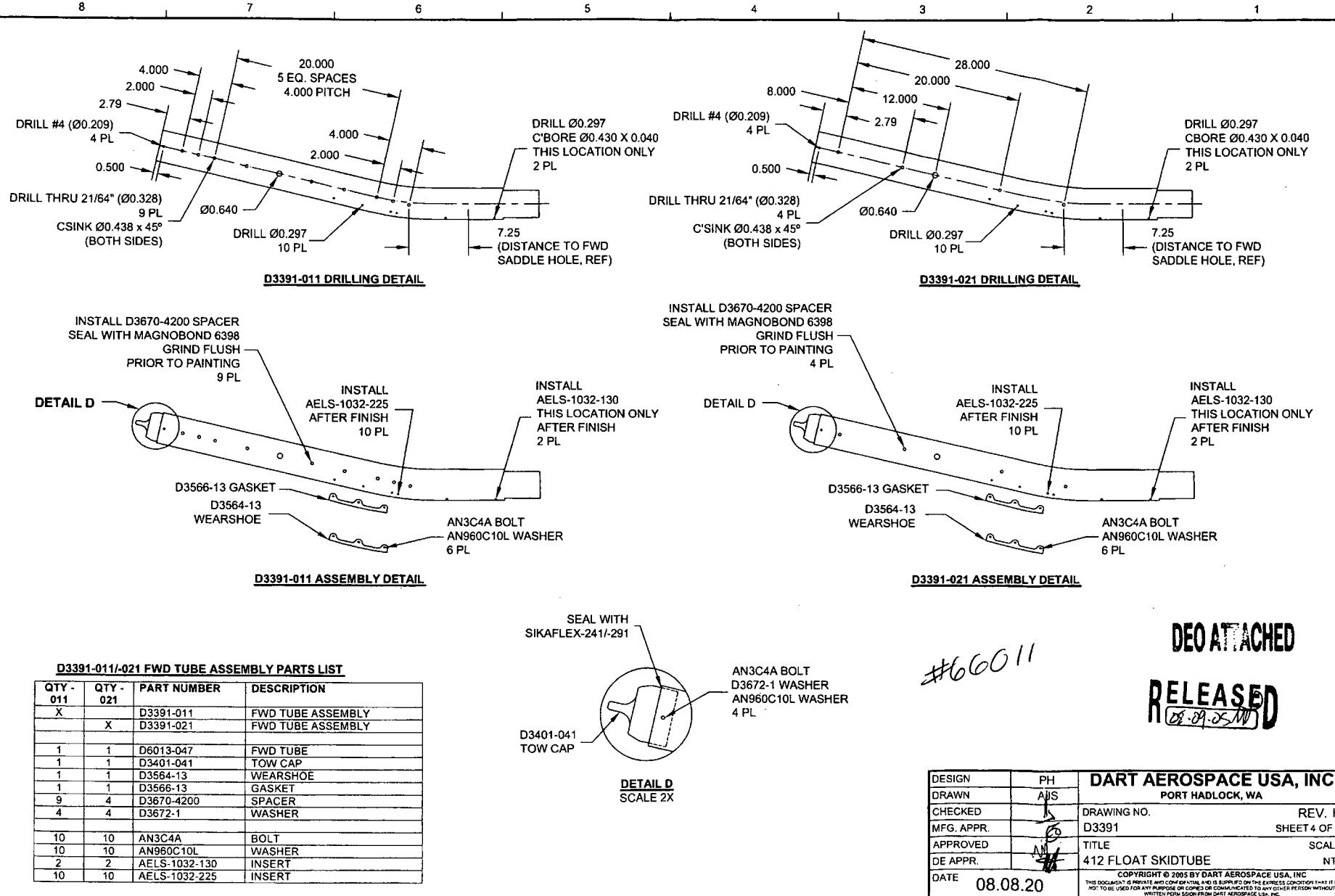
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08-08-20

Dart Aerospace Ltd

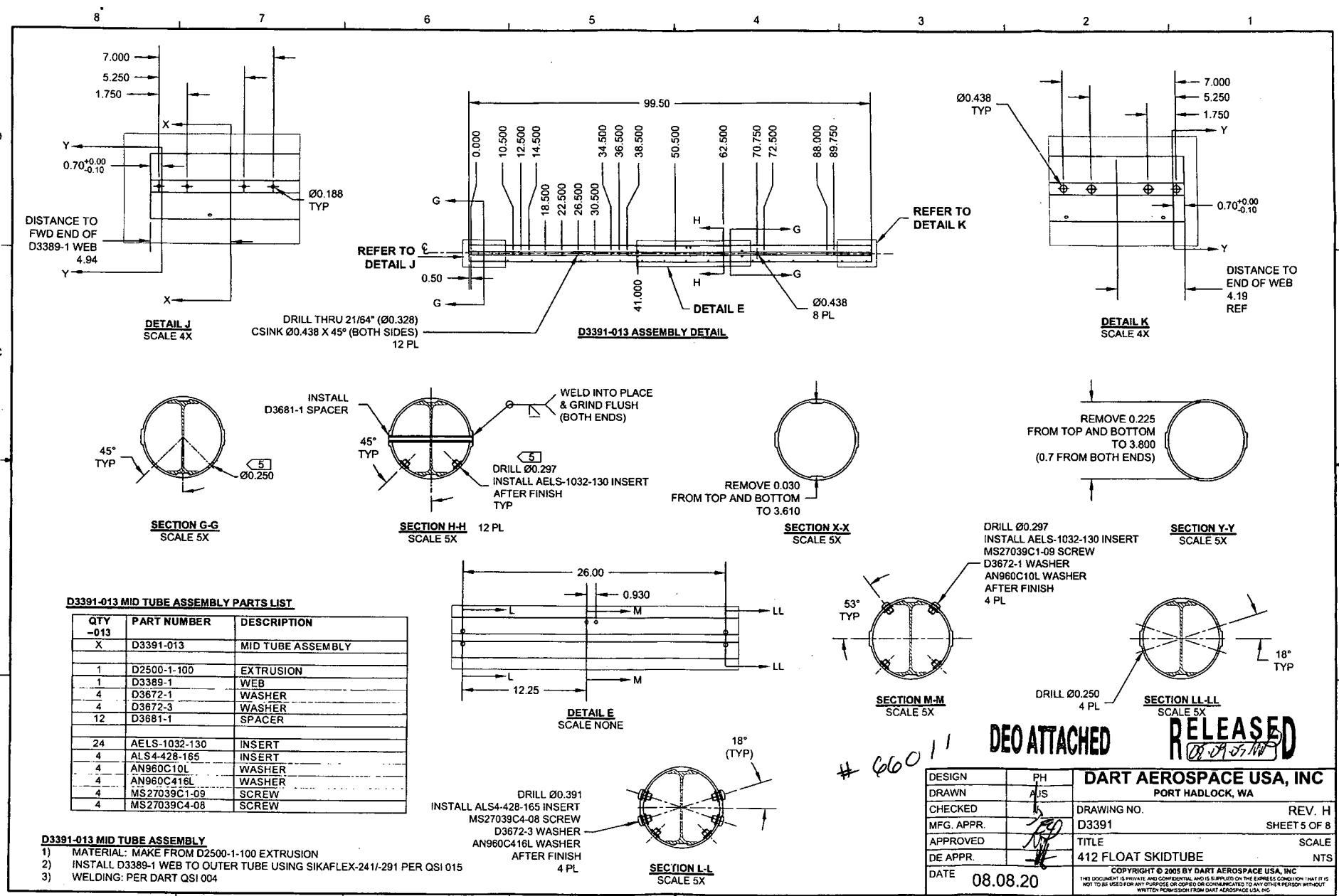
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



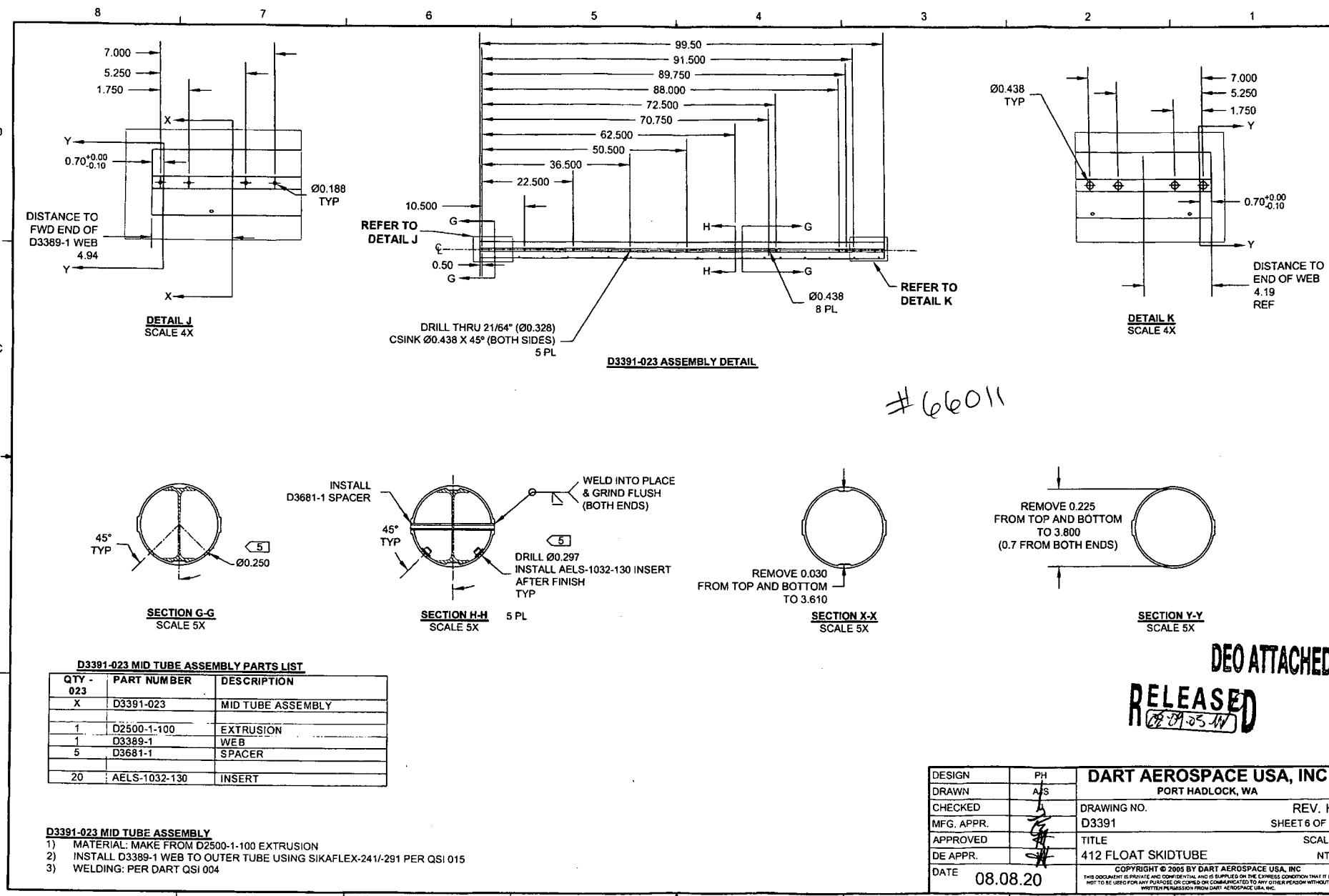
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NOTE: Date & initial all entries



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08.08.2005

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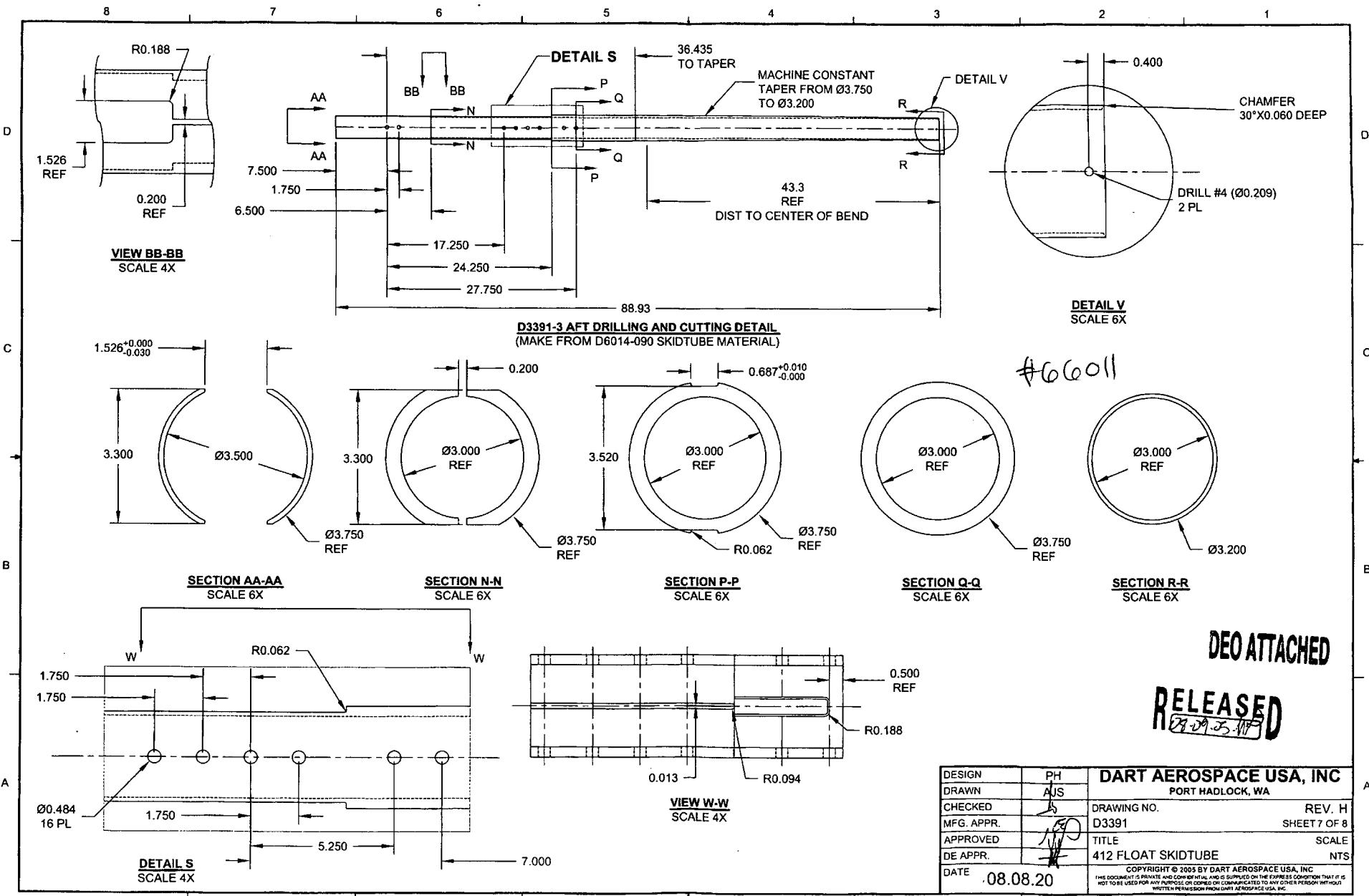
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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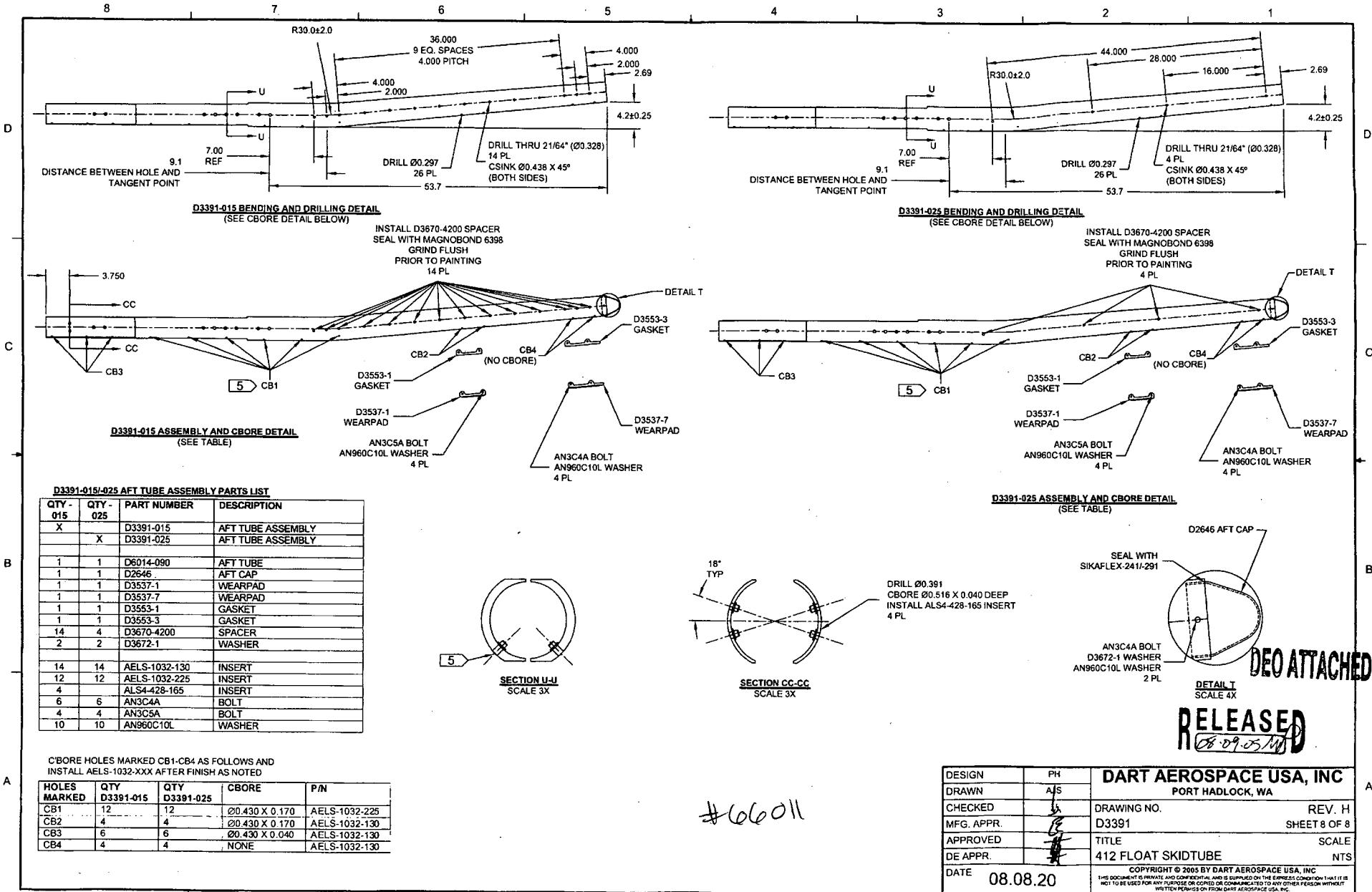
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>(P)</i>	CHECKED <i>AA</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>AA</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.~~

RELEASED
2010-02-02

MP

#66011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng.	Sign & Date			

NOTE: Date & initial all entries